

Work Order ID 86326

June-27-12 11:10:27 AM

86326

PRELIMINARY ISSUE

Page 1

Item ID: D4503-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Door Skin

Start Date: 27/06/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/27

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4503	pb1								
100	FLOW WATER JET	0.00							
100									
Waterjet		0.00				5	0		Jm 12-7-8
FLOW CNC Waterjet	Memo								
<u>6061.032</u>	1-Cut as per Dwg								
	Dwg Rev: <u>PB1</u>								
	Prog Rev: <u>PB1</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC		0.00				5	0		Jm 12-7-8
Quality Control	Memo								
120	QC8- Inspect parts - second check	0.00							
120									
QC		0.00							
Quality Control	Memo								

Scrap B120822
Wrong material

- inspected by PB1
Dwg only
8/2/2009

FS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00				5	MG	12-7-9	
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location:	0.00							
150									
Packaging	Memo	0.00							
Packaging									

inspect to Rev PB1

Dis only

Scraplog (S)

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 02 Jul 12 AUTH W

RELEASED _____ DATE _____

mf
12-08-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 1

June-27-12 11:10:35 AM

Work Order ID: 86326

86326

Parent Item: D4503-1

D4503-1

Parent Item Name: Upper Door Skin

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 11.12.28 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased		No		100	sf	260.1060	8.3788	44.09895			

M6061T6S 0.32

6061-T6 Sheet 0.032"

**

Jm 12-6-28

Location

Loc Qty

Loc Code

MAT021

260.106

118106

46.136

120218

20.13

120285

42.24

121099

151.6

122311

~~121099~~

122311

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

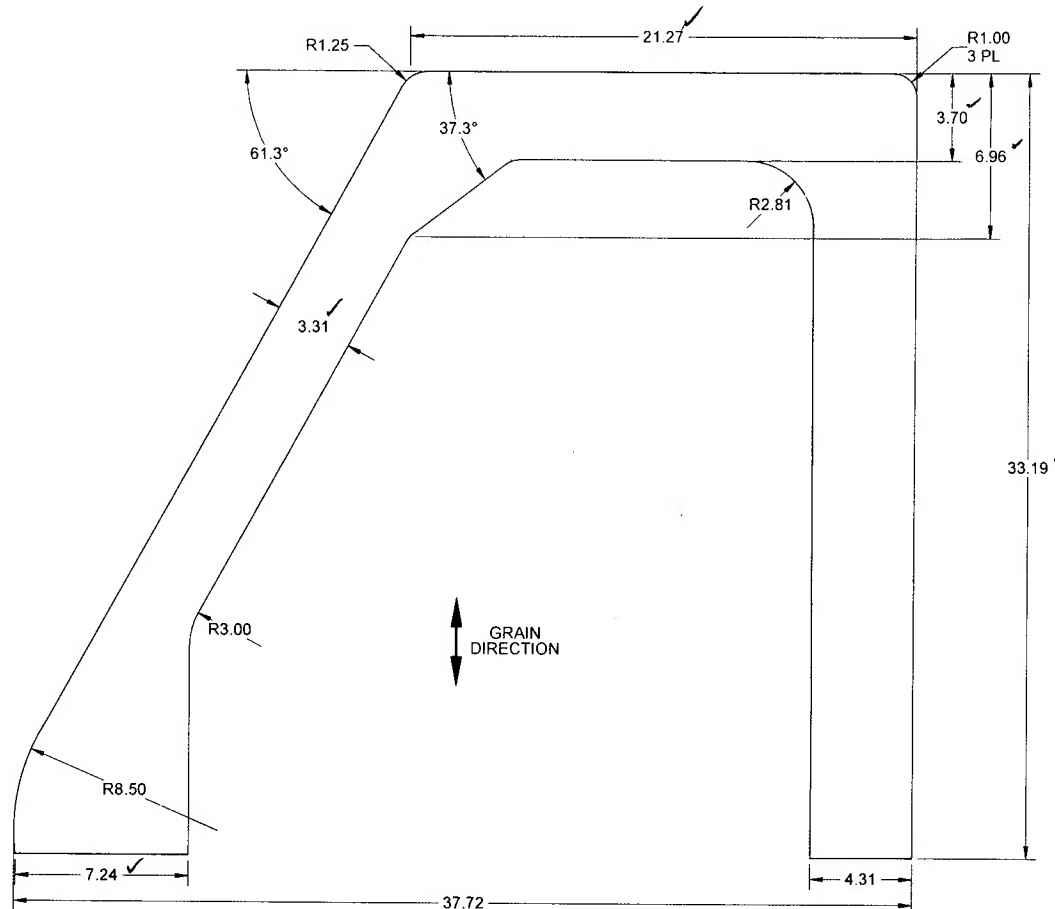
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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PRELIMINARY B1
12.06.26 (AJS)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86326 MLJ
12/06/27

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.06 lbs
- 8) ALL DIMENSIONS AND FEATURES NOT SHOWN TO BE DEFINED PER
DRAWING FILE "D4503-1-REVPB1.DXF"
- 9) FORM PART TO FINAL SHAPE AT NEXT ASSY

D4503-1 UPPER DOOR SKIN

PB1	PRELIMINARY: COMPLETE REDESIGN	AJS	12.06.26
A	NEW ISSUE	AJS	12.03.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D4503	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		UPPER DOOR SKIN	NTS
DATE	12.06.26	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	